

Work Order ID 64985

Wednesday, January 05, 2011 1:01:19 PM



Page 1

Item ID:	D4030-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Long Basket Assembly (350)				Stop	
Start Date:	1/5/2011	Start Qty:	1.00			
Required Date:	1/14/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	1/6/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

ES 11/01/24 @

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Sulocky

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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**Insp.
Stamp**

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Packaging

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Quality Control

11/24/5f

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MF

11-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 1

Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)




Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC
revC DD 10.08.18 verified by:EC
IPP Rev:B as
IPP Rev:C as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	0.0000	1	1			
D2535  Spring		Manufactured	No			100	Each	64.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		64							
				58331		24							
				64280		40							
D2537  Bushing		Manufactured	No			100	Each	36.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST504		36							
				62393		6							
				64064		30							
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1	1			
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1	1			

B644430

B649870

B649890

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3917-3



Washer

Manufactured No

100 Each

30.0000

6

6



EP 11/01/24

Location

Loc Qty

Loc Code

ST095

29

64589

29

6

ST096

1

57144

1

D3953-3



Gas Spring Stud, Lid

Manufactured No

100 Each

1.0000

2

2



EP 11/01/24
B65052 (2x)

Location

Loc Qty

Loc Code

ST100

1

64020

1

D3953-7



Spring Spacer

Manufactured No

100 Each

1.0000

2

2



EP 11/01/24
B65053 (2x)

Location

Loc Qty

Loc Code

ST101

1

63674

1

D3953-9



Gas Spring Washer

Manufactured No

100 Each

13.0000

2

2



EP 11/01/24

Location

Loc Qty

Loc Code

ST100

11

64450

11

2

ST103

2

60008

2

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 3

Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-17



Gas Spring Spacer

Manufactured No

100 Each

5.0000

2

2



EP 11/01/24
865138

Location

Loc Qty

Loc Code

ST101

5

57143

1

64021

4

Manufactured No

100 Each

22.0000

1

1



EP 11/01/24

Location

Loc Qty

Loc Code

ST

3

59213

3

ST097

19

64810

19

Manufactured No

100 Each

11.0000

1

1



EP 11/01/24

Location

Loc Qty

Loc Code

ENG

5

56407

5

ST102

6

57145

2

59214

4

Manufactured No

100 Each

20.0000

1

1



EP 11/01/24

Location

Loc Qty

Loc Code

ST272

20

64285

20

D3969-3



Spring (Basket Lid)

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-14A



Bolt

Purchased

No

100

Each

72.0000

4

4



EBH/01/24

Location

Loc Qty

Loc Code

ST351

72

114941

22

115108

50

4

AN3-16A



Bolt

Purchased

No

100

Each

108.0000

2

2



EBH/01/24

Location

Loc Qty

Loc Code

ST352

108

114752

58

116419

50

2

AN5-17A



Bolt

Purchased

No

100

Each

58.0000

4

4



EBH/01/24

Location

Loc Qty

Loc Code

ST339

58

115594

8

116003

50

4

AN4-12



Bolt

Purchased

No

100

Each

32.0000

3

3



EBH/01/24

Location

Loc Qty

Loc Code

ST357

32

114784

7

116419

25

2

1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN310-4



NUT

Purchased

No

100

Each

33.0000

3

3



Ep 11/01/24

Location

Loc Qty

Loc Code

ST324

33

116075

33

3

AN310C4



Nut

Purchased

No

100

Each

16.0000

2

2



Ep 11/01/24

Location

Loc Qty

Loc Code

ST349

16

114306

16

2

MS21042L3



Nut

Purchased

No

100

Each

1,746.000

6

6



Ep 11/01/24

Location

Loc Qty

Loc Code

ST300

1746

114784

9

115835

833

116373

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116391

900

6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

100

Each

1,185.000

4

4



Nut

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1159

115156

5

115594

500

116104

158

116105

496



ES 11/01/24

MS24665-151

Purchased

No

100

Each

574.0000

3

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

574

17566

574



ES 11/01/24

MS24665-300

Purchased

No

100

Each

32.0000

2

2



Cotter Pin

Location

Loc Qty

Loc Code

ST309

32

110123

32



ES 11/01/24

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Work Order ID: 64985

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0432P

Purchased

No

100

Each

238.0000

6

6



Washer

Location

Loc Qty

Loc Code

ST275

238

112940

92

114405

1

114576

4

114718

2

116169

1

116391

138



6
6
1/5/11/01/24

NAS1149F0563P

Purchased

No

100

Each

158.0000

4

4



Washer

Location

Loc Qty

Loc Code

ST298

158

114576

158



4
4
1/5/11/01/24

NAS1149F0332P

Purchased

No

100

Each

319.0000

8

8



WASHER

Location

Loc Qty

Loc Code

ST275

319

18057

319



8
8
1/5/11/01/24

NAS1149C0432R

Purchased

No

100

Each

208.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST297

208

114292

50

114742

67

116304

91



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1/5/11/01/24

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	B2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	1	D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8	8	NAS1149F0332P	WASHER
31	2	2	NAS1149C0432R	WASHER

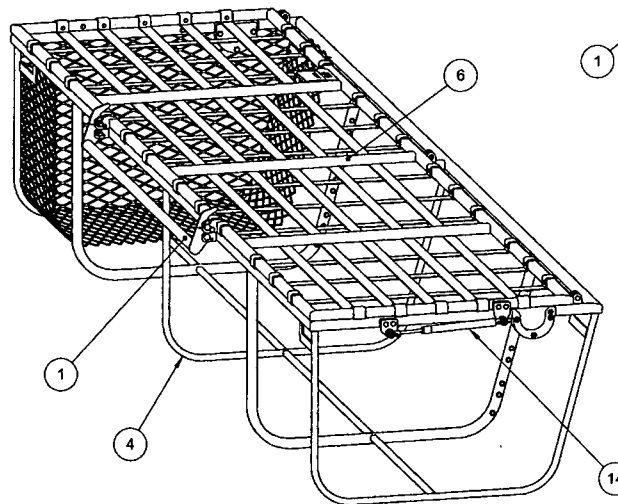
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

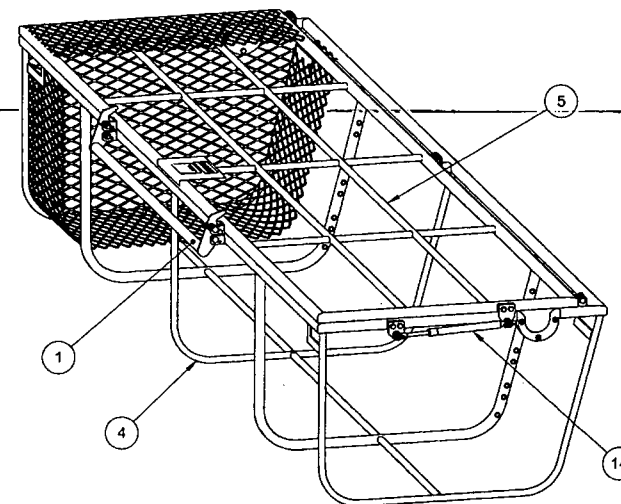
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 114985

11-01-5



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-12
ECN 10-596

C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	JPH		
MFG. APPR.	JPH		
APPROVED	JPH		
DE APPR.	JPH		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4030 TITLE LONG BASKET ASSY (350) REV. C SHEET 1 OF 3 SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

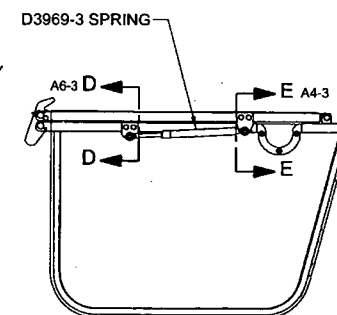
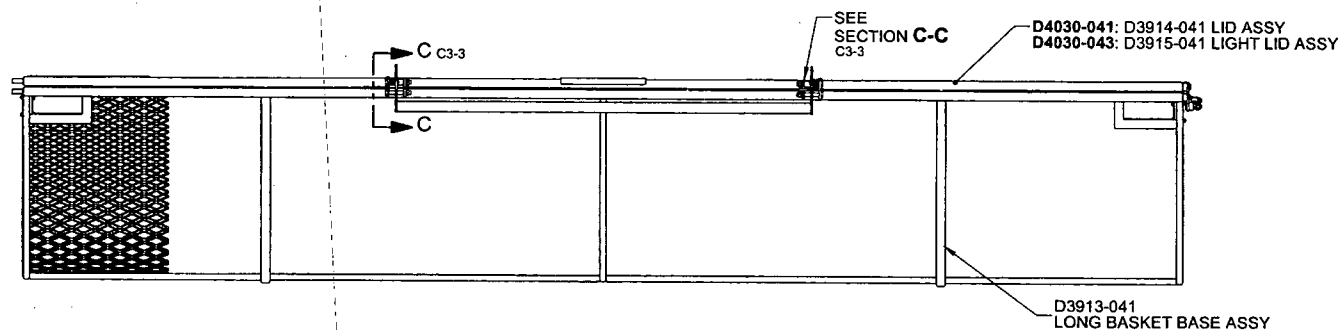
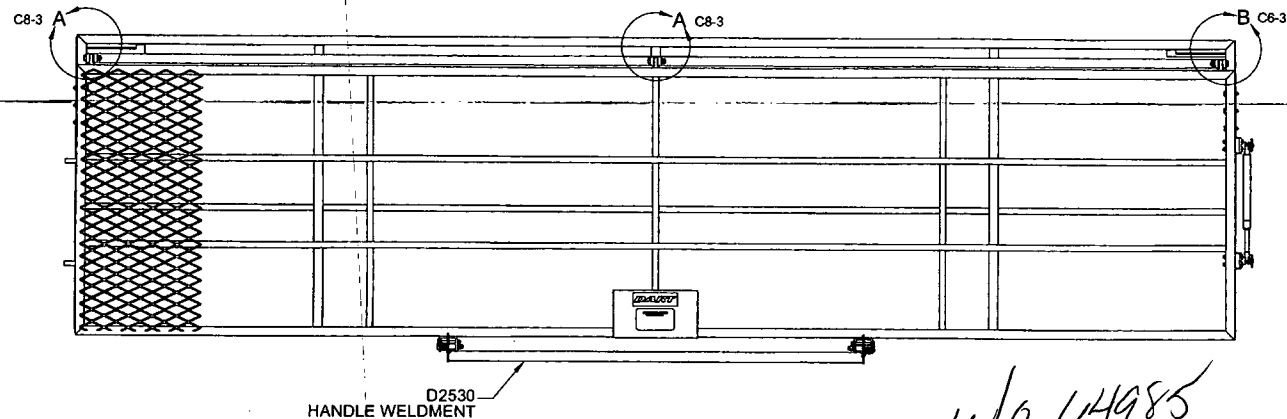
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	145	DART AEROSPACE LTD	
DRAWN	145	HAWKESBURY, ONTARIO, CANADA	
CHECKED	145	DRAWING NO.	REV. C
MFG. APPR.	SES	D4030	SHEET 2 OF 3
APPROVED	145	TITLE	SCALE
DE APPR.	145	LONG BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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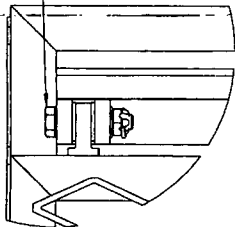
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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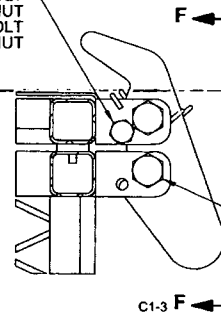
NOTE: Date & initial all entries

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL A D8-2
D5-2

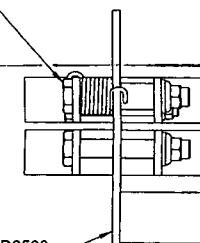
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

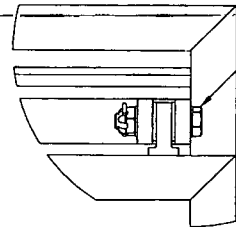
D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-2

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

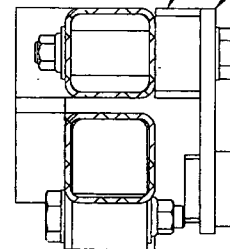
D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL



SECTION E-E B1-2

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	3	HAWKESBURY, ONTARIO, CANADA	
CHECKED	3	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4030	SHEET 3 OF 3
APPROVED	JFS	TITLE	SCALE
DE APPR.	JFS	LONG BASKET-ASSY (350) — NTS	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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